



Dart Aerospace Ltd.
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D2281

Job Sheet 200968



Part No: D2281

Job Qty: 40 pcs

Part Name: Jack Saddle



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/20/19

Job Tracking No:

Due Date: 10/31/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV G IPP Rev:A Removed from 9 Digit 05-12-02 JLM IPP: rev B

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	40 pcs		10/31/19	0.17	2.10	Waterjet - Flow		
120	QC 8	40 pcs		10/31/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
140	Small Fab - Brake NC - B4B	40 pcs		10/31/19	0.25	1.01	Small Fab - Brake - 1 - B4B		
							Small Fab - Brake - 2 -		

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Container No: S225701

Part: D2281

Job No: 200968

Serial No/Batch: S225701

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/23/19

9/20/2019

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				B4B	
				Small Fab - Brake - 3 - B4B	
150	QC 5	40 pcs	10/31/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
					QC 5 - 61
					QC 5 - 81
160	Packaging 3-1 - Stock - B4B	40 pcs	10/31/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
170	QC 21 - SA	40	10/31/19	0.00 0.00	QC 21 - SA - 21

DAS
OCT 23 2019 40
9-89

12

DAS
21
9-39
NOV 05 2019

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pcs

QC 21 - SA - 70

QC 21 - SA - 53

Part Op 100 - 1-Cut as per Dwg Dwg Rev: G Prog Rev: G 2-Deburr if necessary

Descriptions: 120 - (QC8- Inspect parts - second check)

140 - Form as per D2281 using D2281-T2

150 - (QC5- Inspect part completeness to step on W/O)

160 - (Identify as per dwg & Stock Location: W/O) LOCATION : WA001-1

170 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S14GA	304SS sheet .080	5 sf (.125 ea)	100-Waterjet - Flow - 1	S216339

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S14GA	5	14	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Jack Saddle	4.468Inches $\pm$ 0.010	4.478 4.458	4.470	
2	Jack Saddle	4.114Inches $\pm$ 0.010	4.124 4.104	4.107	
3	Jack Saddle	2.933Inches $\pm$ 0.010	2.943 2.923	2.932	
4	Jack Saddle	1.535Inches $\pm$ 0.010	1.545 1.525	1.536	
5	Jack Saddle	0.354Inches $\pm$ 0.010	0.364 0.344	0.357	
6	Jack Saddle	0.354Inches $\pm$ 0.010	0.364 0.344	0.353	
7	Jack Saddle	0.604Inches $\pm$ 0.010	0.614 0.594	0.610	
8	Jack Saddle	2.000Inches $\pm$ 0.010	2.010 1.990	2.000 1.9995	
9	Jack Saddle	3.396Inches $\pm$ 0.010	3.406 3.386	3.397	
10	Jack Saddle	3.646Inches $\pm$ 0.010	3.656 3.636	3.645	
11	Jack Saddle	4.000Inches $\pm$ 0.010	4.010 3.990	4.004	
12	Jack Saddle	1.525Inches $\pm$ 0.010	1.535 1.515	1.525	
13	Jack Saddle	2.475Inches $\pm$ 0.010	2.485 2.465	2.477	
14	Jack Saddle	0.323Inches + 0.006 - 0.001	0.329 0.322	0.326	Diameter
15	Jack Saddle	0.080Inches $\pm$ 0.010	0.090 0.070	0.076	

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WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Entered: _____ Date: _____

Route update only ☐

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube Machining ☐
Large Fab ☐
Cross tube ☐
Small Fab ☐
Finishing ☐
Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐
Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

MRB (QS1042)

Sequence #: _____

QTY Affected: _____

Disposition

Description Work Order Deviation

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Other/Details: _____
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐
Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐